



EVO-STIK 6090

SOLVENT BASED ADHESIVE

KEY FEATURES

- Bonds a variety of soling materials
- Long tack retention time
- Excellent adhesion to leather

DESCRIPTION

Bostik 6090 is a free flowing, solvent-borne formulation based on polychloroprene rubber.

RECOMMENDED USE

Bostik 6090 is used in footwear manufacture for sole attaching, having excellent adhesion to leather and composition, resin and microcellular soling materials.

IMPORTANT

Before embarking on any work involving **Bostik 6090** the safety data sheet should be carefully studied by those carrying out the work.

METHOD OF USE

APPLICATION & BONDING

- Prepare the soling materials surfaces in the appropriate manner and apply **Bostik 6090**, usually by extrusion type machinery. This adhesive is also suitable for application by a through-feed sole cementing machine providing it is used continually. If used intermittently then **Bostik 6092** should be used instead (to overcome the problem of adhesive thickening). **Bostik 6090** can also be applied by brush.
- Since **Bostik 6090** is slow drying it is usual for the adhesive coated soles to be allowed to dry overnight but under certain conditions a drying time as short as 4 hours can be used.
- Apply **Bostik 6090** to the upper material and allow a minimum drying time of 1 hour. This can be reduced if required, by forced drying.
- Reactivate the dried adhesive on one of the coated surfaces at a temperature of 85 – 90°C by means of a high intensity heat activating unit (“flash activation”). Bring the two surfaces together under pressure using a correctly adjusted sole attaching press.
- Bonding should be carried out within the tack retention times of the applied adhesive, these being:
 - 3 days maximum on uppers
 - 3 days maximum on soles (uppers heated).
 - 10 days maximum on soles (soles heated, adhesive applied by through-feed sole cementing machine).
 - 28 days maximum on soles (soles heated, adhesive applied by extrusion).

- As an alternative to heat reactivation a cold bonding technique can be used. The adhesive coated surfaces are brought together under pressure after allowing both surfaces to dry for approximately 30 minutes.

TYPICAL CHARACTERISTICS

Physical form	Semi-viscous liquid
Colour	Fawn-pale brown
Odour	“Sweet”
Chemical type	Polychloroprene rubber/resin blend
Solvent	Mixture of light petroleum spirit, ketone and toluene
Flammability	Highly flammable
Flash point [closed cup]	In the group -18 to -7°C
Viscosity Brookfield RVT 20rpm at 25°C [P]	Approx. 55
Total solids content [%]	Approx. 27
Relative density	Approx. 0.86
Cleaner	Bostik Cleaner/Thinner M501 for cleaning application equipment

BSI STANDARDS



PACKAGING

For current pack sizes please contact the Customer Service Department.

STORAGE

Store in a cool, dry, well ventilated flame proof area in the temperature range 5 – 25°C.

SHELF LIFE

At least 12 months closed in original container stored under the above conditions.

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SMART HELP

Please contact your local representative

